

Ship 1 - 28/03

Dart Aerospace Ltd.

Date: Tuesday, 3/18/2008 3:54:24 PM
User: Kim Johnston

Process Sheet

13

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS KIT
Job Number : 38078	
Estimate Number : 12866	
P.O. Number :	Part Number : D412702043B
This Issue : 3/18/2008 S.O. No. :	Drawing Number : IIN D412-702 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 37699	Material :
Written By :	Due Date : 3/28/2008 Qty: 2 Um: Each
Checked & Approved By : <u>H 08 03 18</u>	
Comment : est rev A 07.05.10 new issue EC est rev C 07.06.20 changed AN44 4A to AN444A EC Est Rev:D 07-07-06 As per Rev E JLM	

Additional Product

Job Number: 

Seq.#: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL

1.0 DC DOCUMENT CONTROL  KS 08.03.19

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP D412-702-043B CHG002

08/03/27

2.0 D412702059 GROMMET KIT

2.0 D412702059 GROMMET KIT 

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
GROMMET KIT
batch: B37355

08/03/25 x(2)

3.0 D412702101B HARNESS ASSEMBLY

3.0 D412702101B HARNESS ASSEMBLY 

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
HARNESS ASSEMBLY
batch: B338097

B32790

4.0 D412702103B HARNESS ASSEMBLY

4.0 D412702103B HARNESS ASSEMBLY 

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
HARNESS ASSEMBLY
batch: 38082

5.0 D412702105B HARNESS ASSEMBLY

5.0 D412702105B HARNESS ASSEMBLY 

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
HARNESS ASSEMBLY
batch: B338038

08/03/24 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/18/2008 3:54:25 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 38078

Part Number: D412702043B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D412702107B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B 37709 1X

B 38084 1X

7.0

D412702109B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B 37710 1X

B 38085 1X

8.0

D35421

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET

batch: 34221

9.0

D35711

GUIDE



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

GUIDE

batch: B 38086

10.0

D35713

GUIDE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

GUIDE

batch: 31869

11.0

D3578041

DOUBLER



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

DOUBLER

batch: B 37309

12.0

D3610041

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET

batch: B 38087

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Tuesday, 3/18/2008 3:54:25 PM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 38078

Part Number: D412702043B

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

D36181

CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

CAP

batch: 32426

14.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: 18057

15.0

AN444A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

bolt

batch: M104806

16.0

MS24693S274

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

batch: M104219

17.0

MS24694S56

SCREW



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

SCREW

batch: M104407

18.0

MS24694S58

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

batch: M11735

19.0

MS24694S60

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch: M11766

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 38078

Part Number: D412702043B

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M106277

21.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: M106785

22.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M106825

23.0

CR3212404

Cherry Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Cherry Rivet

batch: M107008

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-043B CHG001

Location:

PPP Rev:

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041A	QTY -043A	QTY -045A	QTY -047A	QTY -049A	Part Number	Description
X					D412-702-041A	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043A	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045A	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047A	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049A	Dart 1-Man 3-Point Forward Facing Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101A	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-042	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103A	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-041	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1			1	D412-702-105A	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-042	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1	1				D412-702-107A	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-042	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1	1				D412-702-109A	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-041	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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WORK ORDER
NO. 38078

QTY -041A	QTY -043A	QTY -045A	QTY -047A	QTY -049A	Part Number	Description
2		2			D412-702-111A	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-043	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
2		2			D412-702-113A	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-044	SHOULDER HARNESS
4*		4*			MS24693S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1			1		D412-702-115A	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-042	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1			1		D412-702-117A	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-041	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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